



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2940-1
Job Sheet 211700



Part No: D2940-1

Job Qty: 8 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/20

Job Tracking No:

Due Date: 8/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2940 REV D IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G 11.08.04 as per dwg rev.C DD verf:EC/IPP Rev.H 19.10.01 DWG revision (ECN 19-829) DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	8 pcs	8/13/20		2.00	19.05	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	8 pcs	8/13/20		0.00	0.00	QC 2 - 1		20/08/15
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S294439



Part: D2940-1

Job No: 211700

Serial No/Batch: S294439

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/17/20

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					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
120 QC 8	8 pcs	8/13/20	0.00	0.00	QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130 Crosstubes - 2 - B4B	8 pcs	8/14/20	0.00	1.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
140 QC 5	8 pcs	8/14/20	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	

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2/28/17

DAS
87 AUG 20 2020
9-89

				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS
				QC 5 - 61	81
				QC 5 - 81	9-89
				QC 5 - 82	
170 Packaging 3-1 - Stock - B4B 8 pcs	8/14/20	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	'89
				Packaging 3 - 8 - B4B	AUG 21 2020
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA 8 pcs	8/14/20	0.00 0.00		QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	AUG 21 2020

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 110 - (QC8- Inspect parts - second check)

120 - (QC8- Inspect parts - second check)

130 - Per note 9 on page 1 of dwg D2940, Prep inner concave surface of support and use DT10658 apply 3M Scotch-Weld as per dwg. *5206999*

140 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG052

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	4 pcs (.5 ea)	100-HAAS 4 Axis	<i>5257649</i>

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK081	4	13	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		
5	3.250 Support	1.633Inches + 0.040 - 0.000	1.673 1.633		
6	3.250 Support	1.493Inches + 0.020 - 0.000	1.513 1.493		
7	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
8	3.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
9	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
10	3.250 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
11	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
12	3.250 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
13	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
14	3.250 Support	0.350Inches + 0.100 - 0.000	0.450 0.350		
15	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
16	3.250 Support	0.150Inches + 0.020 - 0.000	0.170 0.150		
17	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
18	3.250 Support	101.640Inches + 4.000 - 0.000	105.640 101.640		
19	3.250 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
20	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
21	3.250 Support	4.118Inches + 0.020 - 0.000	4.138 4.118		

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DART AEROSPACE LTD		Work Order: 211700
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: <u>C</u> <u>D</u>	Page 1 of 1

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FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.140	0.190		.165	.170	.169	.168	.165
AB	0.040	0.060		.049	.048	.049	.049	.049
AC	Ø0.187	Ø0.193		.188	.188	.188	.188	.188
AD	Ø0.260	Ø0.267		.261	.261	.261	.261	.261
AE	0.143	0.163		.159	.158	.160	.157	.160
AF	1.485	1.525		1.501	1.503	1.502	1.505	1.500
AG	3.510	3.530		3.527	3.528	3.524	3.522	3.527
AH	0.350	0.450		.370	.370	.370	.370	.370
AI	4.930	4.990		4.960	4.960	4.960	4.958	4.959
AJ	0.140	0.180		.164	.163	.162	.163	.160
AK	0.140	0.180		.164	.164	.165	.164	.162
AL	2.322	2.342		2.330	2.332	2.333	2.336	2.333
AM	0.090	0.110		.105	.103	.102	.103	.103
AN	0.040	0.060		.05	.049	.048	.05	.049
AO	0.140	0.160		.149	.151	.150	.151	.150
AP	R0.240	R0.260		R.25	R.25	R.25	R.25	R.25
AQ	R0.053	R0.073		R.063	R.063	R.063	R.063	R.063
AR	R0.053	R0.073		R.063	R.063	R.063	R.063	R.063
AS	R0.240	R0.260		R.25	R.250	R.250	R.25	R.25
AT	R0.470	R0.530		R.50	R.50	R.50	R.50	R.50
AU	R0.920	R0.980		R.95	R.95	R.95	R.95	R.95
AV								
AW								
Accept/Reject								

Measured by: <u>AL DAS</u>	Date: <u>20/08/15</u>
Audited by: <u>52</u>	Date: <u>20/08/15</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	
F	20.02.04	Dwg Rev and dimensions updated	MD	DP

DART AEROSPACE LTD		Work Order: 2117ex
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: <i>CD</i> ^{DAS 35 9-89}	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	27	38	49	510
HAAS Section								
AA	0.140	0.190		.168	.172	.172		
AB	0.040	0.060		.049	.048	.046		
AC	Ø0.187	Ø0.193		.188	.188	.188		
AD	Ø0.260	Ø0.267		.261	.261	.261		
AE	0.143	0.163		.161	.156	.158		
AF	1.485	1.525		1.500	1.501	1.5		
AG	3.510	3.530		3.527	3.527	3.525		
AH	0.350	0.450		.373	.37	.37		
AI	4.930	4.990		4.960	4.96	4.96		
AJ	0.140	0.180		.160	.16	.16		
AK	0.140	0.180		.162	.162	.162		
AL	2.322	2.342		2.330	2.332	2.33		
AM	0.090	0.110		.102	.102	.102		
AN	0.040	0.060		.046	.052	.049		
AO	0.140	0.160		.151	.148	.148		
AP	R0.240	R0.260		R.250	R.25	R.25		
AQ	R0.053	R0.073		R.063	R.06	R.06		
AR	R0.053	R0.073		R.063	R.06	R.06		
AS	R0.240	R0.260		R.250	R.25	R.25		
AT	R0.470	R0.530		R.500	R.5	R.5		
AU	R0.920	R0.980		R.95	R.95	R.95		
AV								
AW								
Accept/Reject								

Measured by: ALAS	Date: 20/08/16
Audited by: 52 9-89	Date: 20/08/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	
F	20.02.04	Dwg Rev and dimensions updated	MC <i>ms</i>	DP

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					